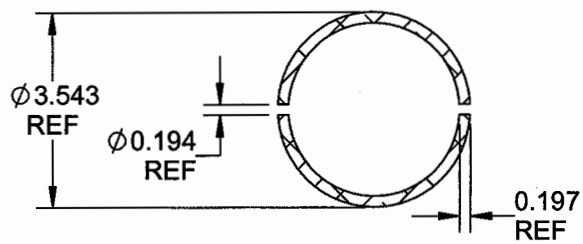
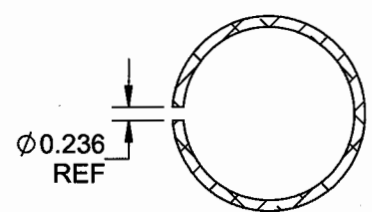


**D135-1027-253 MID HEIGHT AFT CROSSTUBE**



**SECTION A-A  
SCALE 2X**



**SECTION B-B  
SCALE 2X**

**UNDER REVIEW  
ECR 425**

- NOTES:**
- 1) MATERIAL: MANUFACTURED FROM D6027-115  
STRAIGHT LENGTH = 114.08±0.06 (BEFORE BENDING / TRIMMING)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: PER QSI 044 6.1
  - 7) WEIGHT: 20.58 lbs
  - 8) MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE SHALL BE NO LARGER THAN 0.25.
  - 9) HOLES TO BE ALIGNED WITHIN 0.005 IN RELATION TO THE HOLE ON OPPOSITE SIDE OF CROSSTUBE.
  - 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
  - 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. TO BE PERFORMED AFTER FINAL POST-BEND GRINDING. ANY ADDITIONAL GRINDING REQUIRES ANOTHER LPI INSPECTION.
  - 12) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 2% BASED ON OD.

**RELEASED**  
2022 MAR 13  
H3 ECR 340

APPROVED

| E          | REMOVE STEP HOLES, ECR 366  | SAD  | 22.02.11 |
|------------|---|--|----------|
| D          | HOLES QTY (2) Ø0.236 ADDED. REASON: FOR INSTALLATION OF OPTIONAL OEM CARGO HOOK FITTING | MW   | 19.09.11 |
| C          | MOVED GH HOLES DIM 8.70 WAS 8.23  | ZF   | 18.10.04 |
| B          | ADD QTY (2) Ø 0.313 HOLES, 3.13 WAS 3.15, 12.08 WAS 12.04. REASON: DESIGN CHANGE        | ML   | 17.05.25 |
| A          | NEW ISSUE   | ML   | 17.01.31 |
| REV.       | DESCRIPTION   | BY   | DATE     |
| DESIGN     | ML  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |          |
| DRAWN      | SAD   |  |          |
| CHECKED    | RF  | DRAWING NO. REV. E   |          |
| MFG. APPR. | DD  | D135-1027-253 SHEET 1 OF 1   |          |
| APPROVED   | CP  | TITLE SCALE  |          |
| DE APPR.   | CP  | MID HEIGHT AFT XTUBE NTS   |          |
| DATE       | 22.02.11  | <small>COPYRIGHT © 2017 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |          |